

**Work Order ID 54316**

Page 1

December 7, 2009 3:10:06 PM

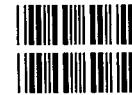
Item ID: D3770-1

Accept

Revision ID:

Item Name: Tube

Start Date: 07/12/2009 Start Qty: 60.00



Cust Item ID:

Required Date: 21/12/2009 Req'd Qty: 60.00



Customer:

Reference:

Approvals:

Process Plan: *PL*Date: *09/12/09*

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D3770	Rev B

100



Small Fab

0.00

Small Fab

Memo

0.00

Small Fab

1-cut tube to length as per dwg D3770-2-drill holes thru to finish size as per dwg D3770 Using DT9410,Locate tube on stop labelled #1 and then drill holes labelled #1-3- deburr

*(60)*
*LJ 10/01/09*

110



QC5- Inspect part completeness to step on W/O

0.00

QC

Memo

0.00

Quality Control

*→ S101107*
*counter  
#60*
*f*

120



Chemical Conversion Coat per QSI005 4.1

0.00

HandFinish

Memo

0.00

Hand Finishing

*BK 10-01-7*
*(60) d.*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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December 7, 2009 3:10:06 PM

Item ID: D3770-1

Accept



Setup Start



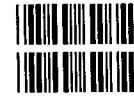
Revision ID:

Stop



Item Name: Tube

Start Date: 07/12/2009 Start Qty: 60.00



Cust Item ID:

Required Date: 21/12/2009 Req'd Qty: 60.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

130

QC3- Inspect Part Finish

0.00

SAD

10-01-07

60



QC

Quality Control

Memo

0.00

140

Identify as per dwg &amp; Stock Location: 250A

0.00



Packaging

Packaging

Memo

0.00

  
 10/01/07 (60)

150

QC21- Final Inspection - Work Order Release

0.00



QC

Quality Control

Memo

0.00

  
 10/01/07 AF  
 MF 10-01-07

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8 7 6 5 4 3 2 1

SHOP COPY

RETURN TO

ENGINEER

UNCONTROLLED

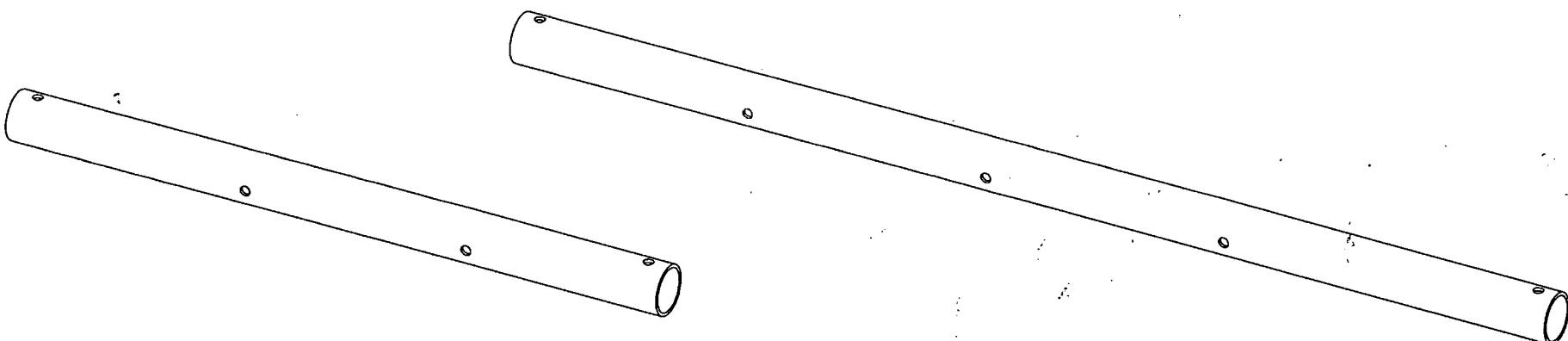
SUBJECT TO AVAILABILITY

WITHOUT EXCEPTION

WORKS DRAWER

NO. 54316

B409-12-7

D3770-1 TUBED3770-3 TUBE

REF  
08.07.10/H

## NOTES:

- 1) MATERIAL: 6061-T6 OR 6061-T62 ALUMINUM TUBING (1.00" X 0.065" WALL) PER WW-T-700/6 OR AMS 4080 OR AMS 4082 OR QQ-A-200/8 OR QQ-A-225/8 (REF. DART SPEC. M6061T6T1.000W.065)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: D3770-1, 0.25 lbs  
D3770-3, 0.40 lbs

8 7 6 5 4 3 2 1

B	CHANGE HOLES SIZE TO 0.201		HS	08.06.23
A	NEW ISSUE		HS	08.06.04
REV.	DESCRIPTION		BY	DATE
DESIGN	HS	DART AEROSPACE LTD		
DRAWN	HS	HAWKESBURY, ONTARIO, CANADA		
CHECKED	PJL	DRAWING NO.	REV. B	
MFG. APPR.	APL	D3770	SHEET 1 OF 3	
APPROVED	VIP	TITLE	SCALE	
DE APPR.		TUBE	NTS	
DATE	08.06.23	COPYRIGHT © 2008 BY DART AEROSPACE LTD		
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8 7 6 5 4 3 2 1

A

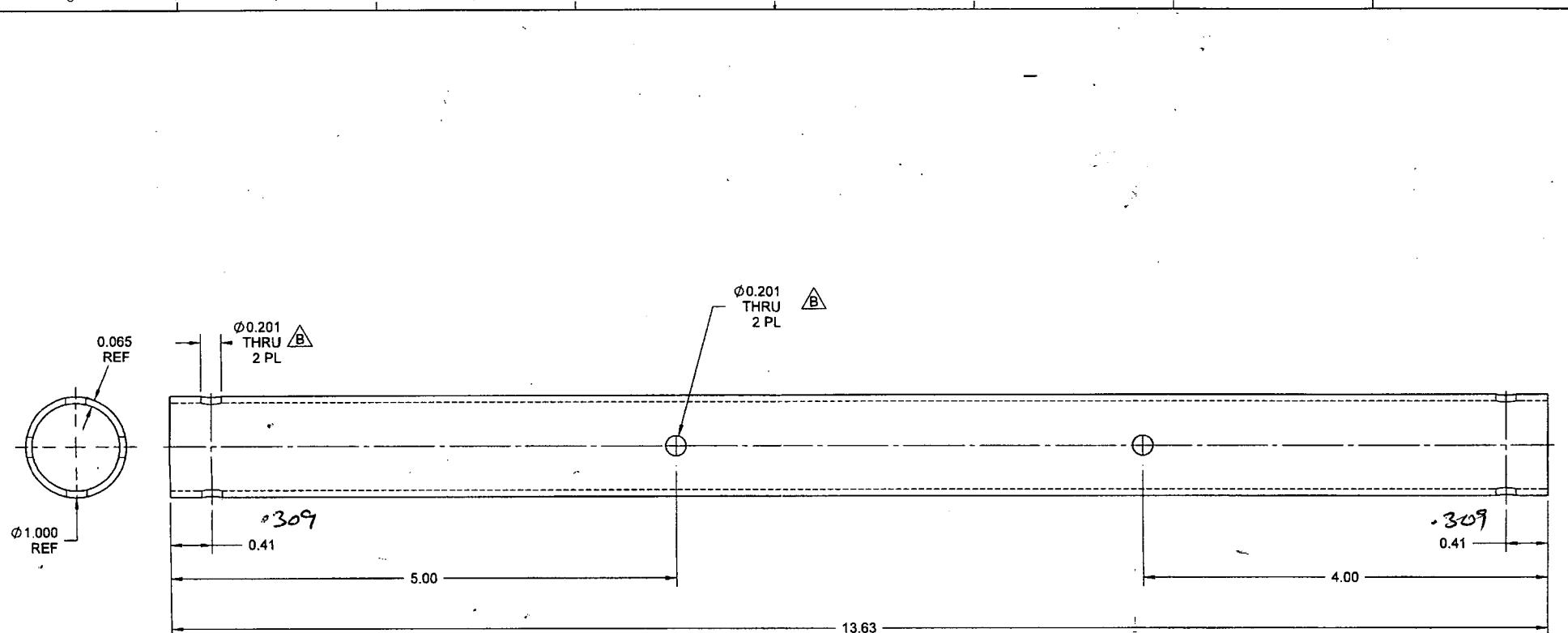
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D3770-1 TUBE

RELEASED  
08-07-17

w/o 54314

DESIGN	HS	DART AEROSPACE LTD
DRAWN	HS	HAWKESBURY, ONTARIO, CANADA
CHECKED		DRAWING NO.
MFG. APPR.		D3770
APPROVED		REV. B
DE APPR.		SHEET 2 OF 3
DATE	08.06.23	TITLE
		SCALE
		NTS

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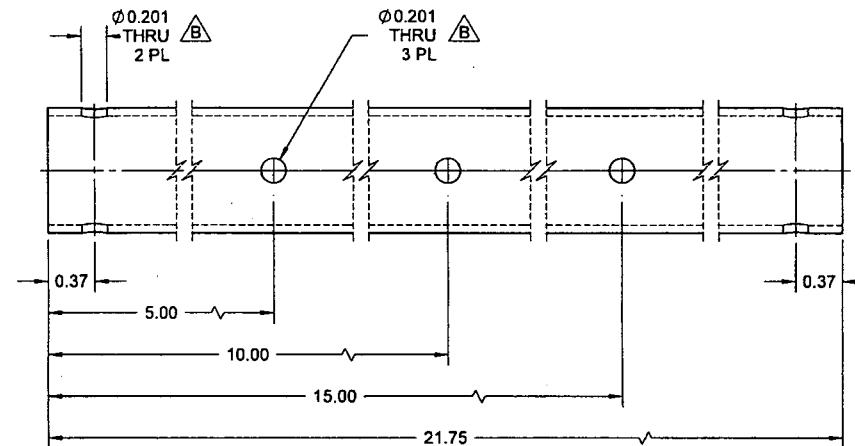
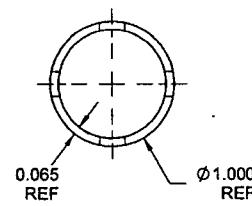
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8 7 6 5 4 3 2 1

D3770-3 TUBE

RELEASED  
08/07/1074

w/o 34316

DESIGN	HS	DART AEROSPACE LTD	
DRAWN	HS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	PJ	DRAWING NO.	REV. B
MFG. APPR.	MJ	D3770	SHEET 3 OF 3
APPROVED	MJ	TITLE	SCALE
DE APPR.	MJ	TUBE	NTS
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